

Date: Wednesday, 5/23/2007 3:46:24 PM
 User: Kim Johnston

Process Sheet

22

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/355 SINGLE CARGO MIRROR
Job Number	: 32517		
Estimate Number	: 10708		
P.O. Number	:	Part Number	: D350561041
This Issue	: 5/23/2007 S.O. No. :	Drawing Number	: IIN D350-561 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31471	Material	:
Written By	:	Due Date	: 6/1/2007 Qty: 5 Um: Each
Checked & Approved By	: <u>07.05.24</u>		
Comment	: Est Rev: Removed Manufacturing 05-11-17 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-561-041CHG005

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

NEE THE STONE CANCEL

3.0	D2011101	Mirror 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2011-101 Mirror

B30376 -

(S) ✓

4.0	D2012101	Arm (23.75)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2012-101 Arm

B31481

(S) ✓

5.0	D2012103	Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2012-103 Arm

B31481

(S) ✓

1 D2012-105 Arm

EP 5/25/07/285

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description :

6.0

D2012105

Arm (31.06)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2012-105 Arm B31483 ✓

7.0

D2012107

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2012-107 Clevis B29883 ✓

8.0

D2012109

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2012-109 Bracket B24558 ✓

9.0

D2012111

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2012-111 Bracket B30300 ✓

10.0

D2012113

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2012-113 Clamp B31484 ✓

11.0

D2012115

Bracket,Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

D2012-115 ~~4 D2022-101~~ Spacer B20543 B20803 (X) ✓ B25581 (X) ✓

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Seq. #:

Machine Or Operation:

Description :

12.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2022-101 Spacer B30543 ✓

13.0

D2856100325

Abrasion Strip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2856-100-(3.25) Abrasion Strip D30822 ✓

14.0

AN34A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-4A Bolt M103287 ✓

15.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-5A Bolt M100188A ✓

16.0

AN36A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN3-6A Bolt M100184 ✓

Handwritten signature/initials
C/S 7/15/285

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Description :

17.0

AN45A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

3 AN4-5A Bolt

17100857 ✓

18.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-10A Bolt

17101291 ✓

19.0

AN960JD10

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 70.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

14 AN960JD10 Washer

17104118 ✓

20.0

AN960JD416

Washer



Comment: Qty.: 9.0000 Each(s)/Unit Total : 45.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

9 AN960JD416 Washer

17103691 ✓

21.0

MS21042L3

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 MS21042L3 Nut (or -3)

17103691 ✓

CP 07/05/28 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D350561041

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 MS21042L4 Nut (or -4) 1102552

CP 5/25/07

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-561-041

Location: _____

PPP Rev: _____

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.06.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-561-041	2.5 lb	+39.0 in	+97.5 in-lb	9.0 in	22.5 in-lb
Single Mirror Installation	1.1 kg	+0.99 m	+1.09 m-kg	0.23 m	0.25 m-kg
D350-561-043	3.2 lb	+40.0 in	+128.0 in-lb	8.8 in	28.2 in-lb
Dual Mirror Installation	1.5 kg	+1.02 m	+1.53 m-kg	0.22 m	0.33 m-kg

5. PARTS LIST

Qty -041	Qty -043	Qty -045	Part Number	Description
X	1	1	D350-561-041	SINGLE MIRROR INSTALLATION
	X		D350-561-043	DUAL MIRROR INSTALLATION
	1	X	D350-561-045	MIRROR KIT
1		1	D2011-101	Mirror
1			D2012-101	Arm
1			D2012-103	Arm
1			D2012-105	Arm
2			D2012-107	Clevis
1			D2012-109	Bracket
1			D2012-111	Bracket
4		2	D2012-113	Clamp
1			D2012-115	Bracket
4			D2022-101	Spacer
4		2	D2856-100-325	Abrasion Strip
1*		1*	D3014-1	Locknut
2		1	AN3-4A	Bolt
2		1	AN3-5A	Bolt
1			AN3-6A	Bolt
3			AN4-5A	Bolt
2			AN4-10A	Bolt
14		6	AN960JD10	Washer
9		2	AN960JD416	Washer
1*		1*	AN960JD416L	Washer
5		2	MS21042L3	Nut (or MS21042-3)
5			MS21042L4	Nut (or MS21042-4)

*INCLUDED AS PART OF D2011-101 MIRROR

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 32517